

Work Order ID 71911

Wednesday, July 13, 2011 12:34:13 PM



PRELIMINARY ISSUE

Page 1

Item ID: D4407-1
Revision ID: PRELIM
Item Name: Bar

Accept



Setup Start



Stop




Start Date: 7/13/2011 Start Qty: 1.00
Required Date: 7/15/2011 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: 
QC:

Date:
Date:

Tooling:

SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Draw Nbr	Revision Nbr
D4407	PA3

100



Mill Conv

Conventional Milling Machine

Memo

1-mill as per Dwg D4407

2-Deburr if necessary

0.00

0.00

0.00

0.00

0.00

0.00

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

SCRAP

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

11/07/13
- inspect to PA3
Dwg only
8/13/13

150



Packaging

Packaging

Identify as per dwg & Stock Location: W/O

Memo

71909

147-28

ⓧ

Work Order ID 71911

Wednesday, July 13, 2011 12:34:13 PM



Page 2

Item ID: D4407-1

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Start Date: 7/13/2011 Start Qty: 1.00

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL
EFFECTIVE 11/02/13 AUTH U
RELEASED _____ DATE _____

Picklist Print

Wednesday, July 13, 2011 12:34:11 PM

Page 1

Work Order ID: 71911

Parent Item: D4407-1

Parent Item Name: Bar



Start Date: 7/13/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.06.06 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	322.1147	5.66	5.957895			



304 BAR .250 x .500



Location

Loc Qty

Loc Code

MAT006

221

116148

78

117842

143

MAT050

101.1147

117176

101.1147

6.0 *AD* 11/07/13

DART AEROSPACE LTD		Work Order: 71911
Description: BAR		Part Number: 24407-1
Inspection Dwg: 4407, Rev: PA3		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

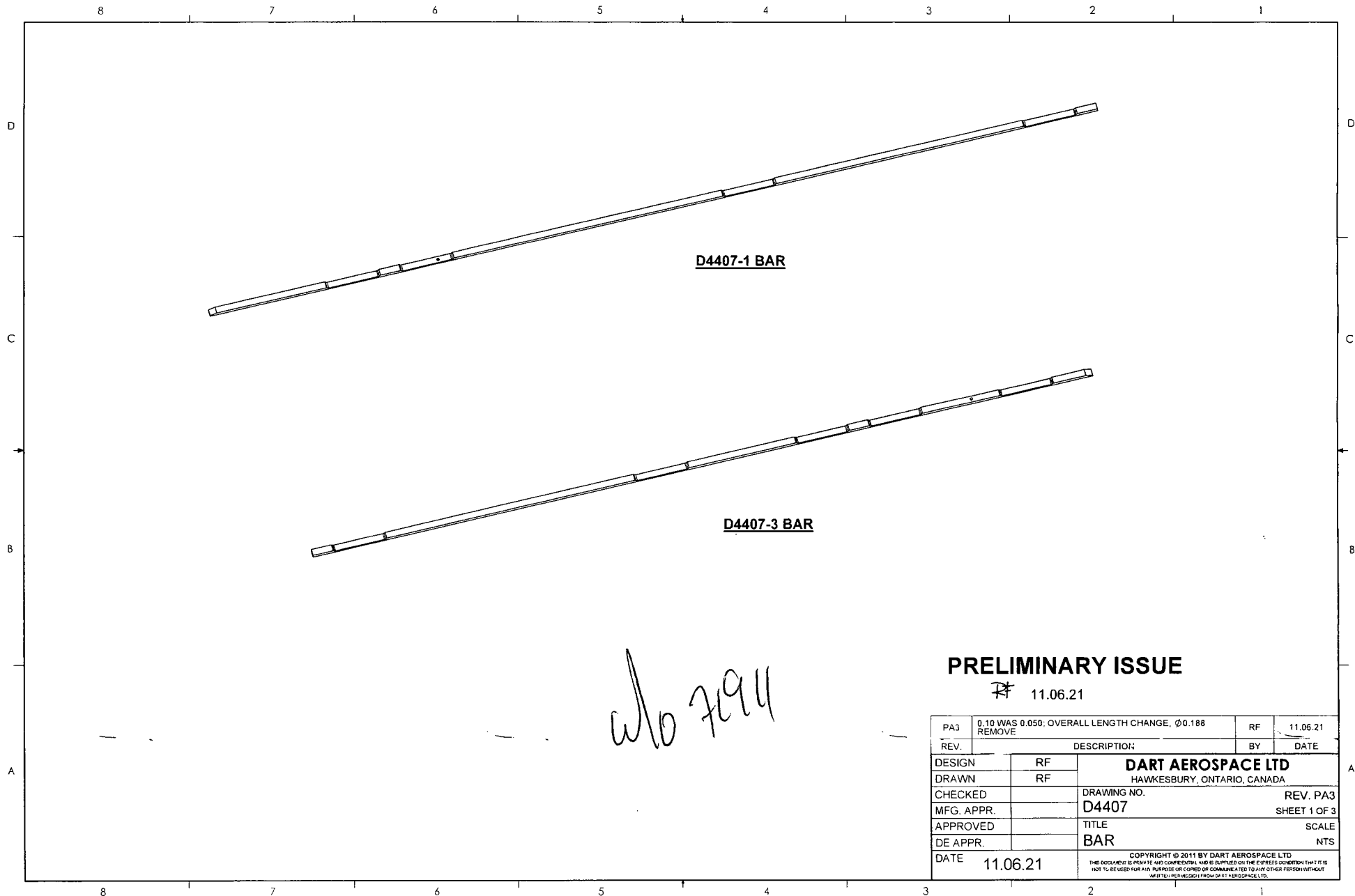
X

X

[illegible]

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: <i>11/07/13</i>	Date: <i>11/07/13</i>	Date:

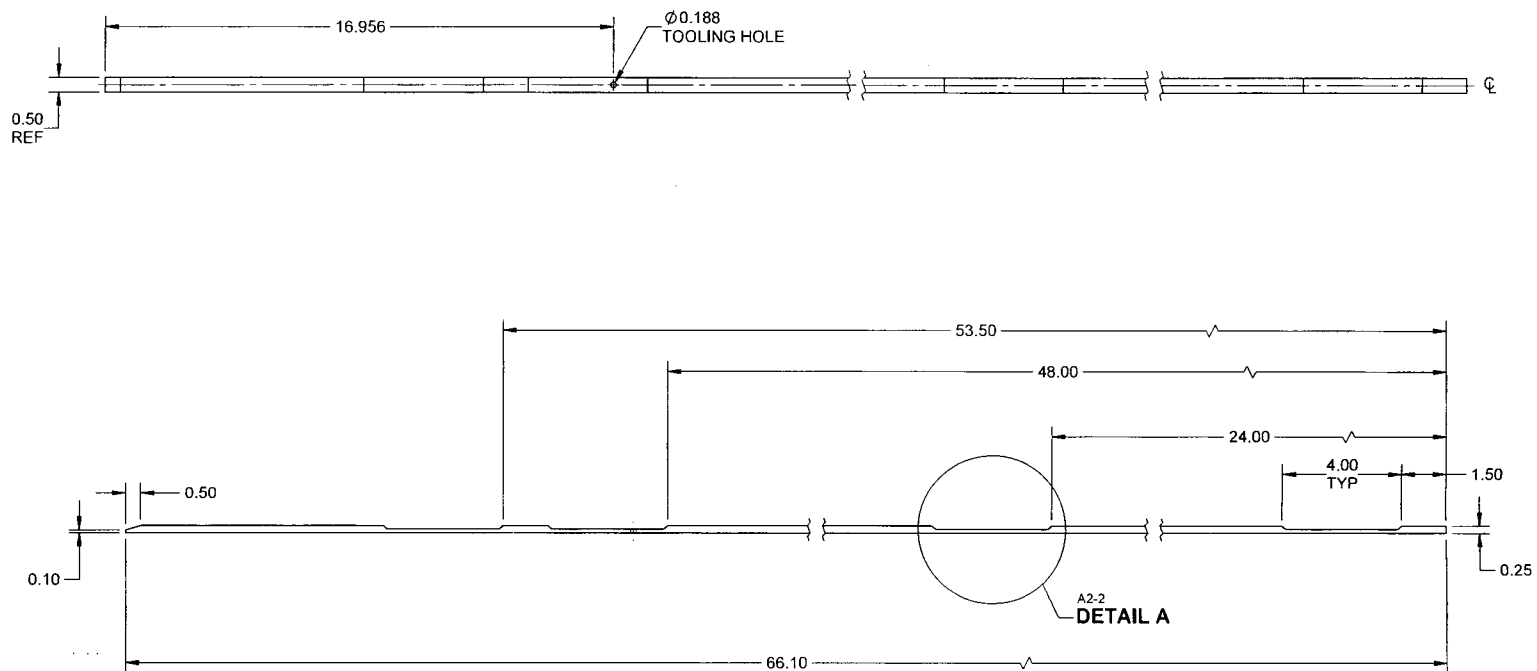
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



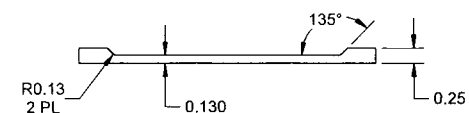
PRELIMINARY ISSUE

11.06.21

PA3	0.10 WAS 0.050; OVERALL LENGTH CHANGE, ϕ 0.188 REMOVE	RF	11.06.21
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PA3
MFG. APPR.		D4407	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
DATE	11.06.21	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4407-1 BAR



DETAIL A
TYP. SCALE 2X

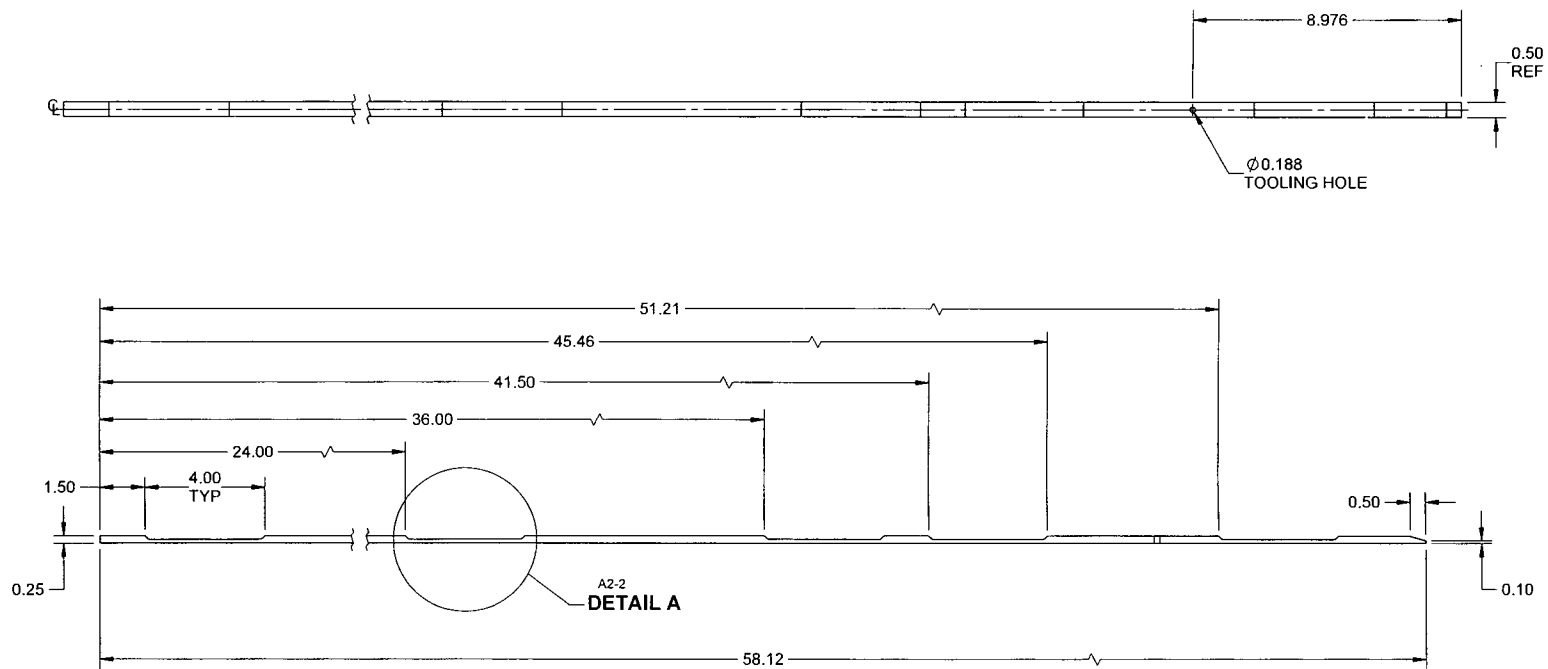
PRELIMINARY ISSUE

11.06.21

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL, 0.250 x 0.500 BAR
PER ASTM A276 OR ASTM 240
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: = 2.11 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D4407	REV. PA3
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE BAR	SCALE NTS
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DATE	11.06.21		



D4407-3 BAR

PRELIMINARY ISSUE

11.06.21

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL, 0.250 x 0.500 BAR
PER ASTM A276 OR ASTM 240
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: = 1.76 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PA3
MFG. APPR.		D4407	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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